



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D135-1027-203
Job Sheet 190480



Part No: D135-1027-203

Job Qty: 1 pcs

Part Name: MID Height AFT Crosstube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/8/19

Job Tracking No:

Due Date: 3/28/19

Created By: Jesse White

Type: SOLD

Description:

Note: IIN-D135-1027 REV.C IPP REV:A 17.10.24 NEW ISSUE DD VERF:JFS IPP REV:B 18.11.08 AS PER IIN
REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		MAR 22 2019 Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	1 pcs	3/28/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



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Container No: S179938



Part: D135-1027-203

Job No: 190480

Serial No/Batch: S179938

Revision: D

Inspector:

Exp Date:

Instructions: TC STC SH18-49 Issue 1 Date 1/10/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
		Other/Details: _____			

110 QC 4	1 pcs	3/28/19	0.00 0.00	Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				QC 4 - 26	
				QC 4 - 28	
				QC 4 - 42	
				QC 4 - 58	
				QC 4 - 6	
130 Packaging 3-1 - Stock - B4B	1 pcs	3/28/19	0.00 0.00	QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
135 DC - 1 - B4B	1 pcs	3/28/19	0.00 0.00	Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
140 QC 21 - FG	1 pcs	3/28/19	0.00 0.00	Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
140 QC 21 - FG	1 pcs	3/28/19	0.00 0.00	Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				DC - 1 - B4B	
				DC - 2 - B4B	
140 QC 21 - FG	1 pcs	3/28/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

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Part Op 100 - (Pick Kit)

Descriptions: 110 - (QC4- 100% Inspect kits for completeness)

130 - Package as per PPP D135-1027-203 Identify and Stock Location :

135 - (Document Control) Photocopy blue file & type labels as per PPP D135-1027-203 CHG 001

140 - (QC21- Final Inspection - Work Order Release)

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job 190480

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310C8	Nut	4 Ea (4 ea)	100-Packaging 1 - Pick Kit	5103998X3 5156 128x1
AN5-44A	Bolt	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5072096
D135-1027-243	MID HEIGHT AFT Crosstube Assembly	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	517969
D5415-1	Med Height Saddle	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5179676
D5416-1	Bushing	4 pcs (4 ea)	100-Packaging 1 - Pick Kit	5035829
D5417-1	Support Plate	4 pcs (4 ea)	100-Packaging 1 - Pick Kit	5036072
D5464-1	Washer	4 pcs (4 ea)	100-Packaging 1 - Pick Kit	5033379
D5541-041	Ground Handling Pin Assembly	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5037615
D5541-3	Ground Handling Nut	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5035389
D5541-5	Ground Handling Washer	2 pcs (2 ea)	100-Packaging 1 - Pick Kit	5159509
MS21042-5	Nut	2 Ea (2 ea)	100-Packaging 1 - Pick Kit	5149145
MS21043-3	Nut	12 Ea (12 ea)	100-Packaging 1 - Pick Kit	5149144
MS21920-32	Clamp	13 Ea (13 ea)	100-Packaging 1 - Pick Kit	5035171
MS24665-306	Cotter Pin	8 Ea (8 ea)	100-Packaging 1 - Pick Kit	51132878-70
NAS1149C0363R	Washer	12 Ea (12 ea)	100-Packaging 1 - Pick Kit	5132615
NAS1149D0563J	Washer	8 Ea (8 ea)	100-Packaging 1 - Pick Kit	5156686
D5720-041	4x			5179666

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	AN310C8	4	21	0
	AN5-44A	2	67	0
	D135-1027-243	1	0	0
	D5415-1	2	0	0
	D5416-1	4	40	0
	D5417-1	4	41	0
	D5464-1	4	32	0
	D5541-041	2	6	0
	D5541-3	2	6	0
	D5541-5	2	2	0
	MS21042-5	2	0	0
	MS21043-3	12	1,382	0
	MS21920-32	13	200	0
	MS24665-306	8	78	0
	NAS1149C0363R	12	645	0
	NAS1149D0563J	8	973	0

Part Specifications

Specifications could not be found.

Plex 2/8/19 2:39 PM dart.white.jesse

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Opt. 105 Pack. 1 B4B

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

5.0 PARTS LIST

For convenience, only the last three digits of the part number are listed on the top row of the table. The quantity of each component which is included in the D135-1027-101 Kit, for example, is as defined in the column labeled -101.

Qty -101	Qty -103	Qty -201	Qty -203	Part Number	Description
X				D135-1027-101	STD HEIGHT FWD CROSSTUBE INSTALLATION
	X			D135-1027-103	MID HEIGHT FWD CROSSTUBE INSTALLATION
		X		D135-1027-201	STD HEIGHT AFT CROSSTUBE INSTALLATION
			X	D135-1027-203	MID HEIGHT AFT CROSSTUBE INSTALLATION
1				D135-1027-141	STD HEIGHT FWD CROSSTUBE ASSY
	1			D135-1027-143	MID HEIGHT FWD CROSSTUBE ASSY
		1		D135-1027-241	STD HEIGHT AFT CROSSTUBE ASSY
			1	D135-1027-243	MID HEIGHT AFT CROSSTUBE ASSY
2	2	2	2	D5411-1 (1)	RUBBER BUSHING
2	2	2	2	D5412-041 (1)	CROSSTUBE CLAMP
2	2	2	2	D5413-1 (1)	CROSSTUBE SUPPORT
4	4	4	4	D5414-1 (1)	SUPPORT BOLT
	2		2	D5415-1	MID HEIGHT SADDLE
2		2		D5415-3	STANDARD HEIGHT SADDLE
4	4	4	4	D5416-1	BUSHING
4	4	4	4	D5417-1	SUPPORT PLATE
4	4	4	4	D5464-1	WASHER
		2	2	D5541-041	GROUND HANDLING PIN
		2	2	D5541-3	GROUND HANDLING NUT
			4	D5541-5	GROUND HANDLING WASHER
2	2			D5677-1	PIN
4	4	4	4	D5720-041	CLAMP
4	4	4	4	AN310C8	NUT, CASTELLATED
2	2	2	2	AN5-44A	BOLT
2	2	2	2	MS21042-5	NUT, SELF LOCKING
8*	8*	12*	12*	MS21043-3	NUT, SELF LOCKING
8*	8*	8*	8*	MS24665-306	COTTER PIN
8*	8*	12*	12*	NAS1149C0363R	WASHER
8*	8*	8*	8*	NAS1149D0563J	WASHER

* Additional hardware provided.

(1) Pre-assembled on D135-1027-141/-143/-241/-243 Crosstube Assemblies.